

Date: Monday, 22/09/2008 10:14:26 AM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: BACK LEG ASSEMBLY
Job Number	: 42152		
Estimate Number	: 13323		
P.O. Number	:	Part Number	: D3782045
This Issue	: 22/09/2008 S.O. No. :	Drawing Number	: D3782 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 22/09/2008 Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 40873	Material	:
Written By	:	Due Date	: 05/10/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUD 08.9.22</u>		
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D37721	Back Leg
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Back Leg batch: <u>B 42240</u>	
3.0	D37871	Foot
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Foot batch: <u>40982</u>	
4.0	D37641	Back Leg Fitting
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Back Leg Fitting batch: <u>40970</u>	
5.0	D3773041	Headrest Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Headrest Assembly batch: <u>40980</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 42152

Part Number: D3782045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D37861	Sleeve
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Sleeve

batch: 40981

JS 08/10/14 (x6)

7.0	AN515A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch: M108880

JS 08/10/14 (x6)

8.0	AN517A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch: M108558 x4 M109059 x2

JS 08/10/14 (x6)

9.0	AN45 15A	EYE BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

EYE BOLT

batch: M108558 M109012

JS 08/10/14 (x6)

10.0	AN415A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

batch: M108868

JS 08/10/14 (x6)

11.0	AN96JD516	Washer
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Comment: Qty.: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)

Washer

batch: M109059

or (NAS1149D0568J)batch:

JS 08/10/14 (x6)

12.0	AN96JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

batch: M108827

or (NAS1149D0463J)batch:

JS 08/10/14 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 10:14:26 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 42152

Part Number: D3782045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch:

M108145

JS 08/10/14 (6)

14.0	MS21042L5	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Nut

batch:

M108161

JS 08/10/14 (6)

15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

FF 08/10/20 (6)

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/20 (6)

17.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 255

8/10/20

SP

(6x)

18.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/21 (6)

Job Completion



mf 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

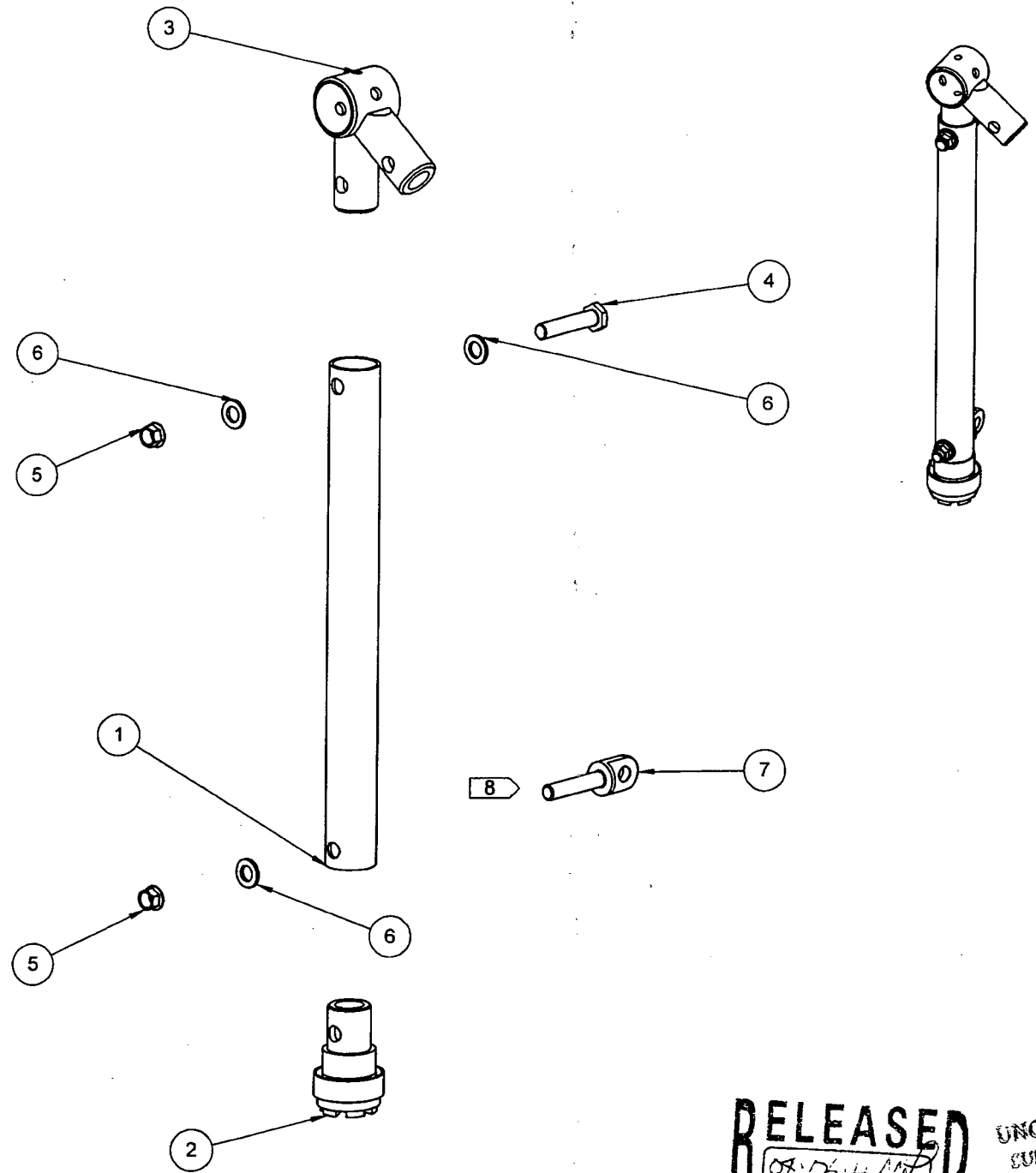
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3768-1	FRONT INBOARD LEG	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN5-13A	BOLT	1
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	3
7	AN45-13A	EYE BOLT	1



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 6 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

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A	NEW ISSUE	HS	08.06.04
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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-044 FRONT OUTBOARD LEG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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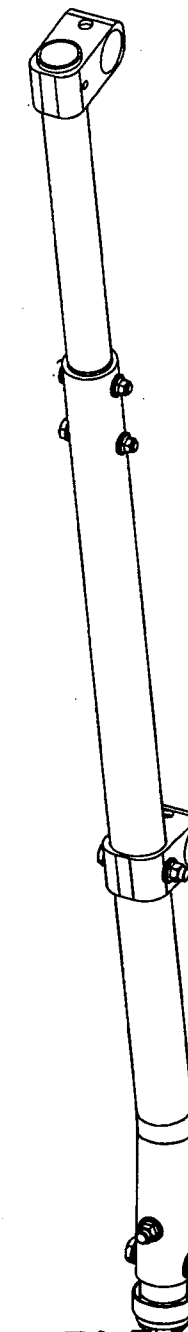
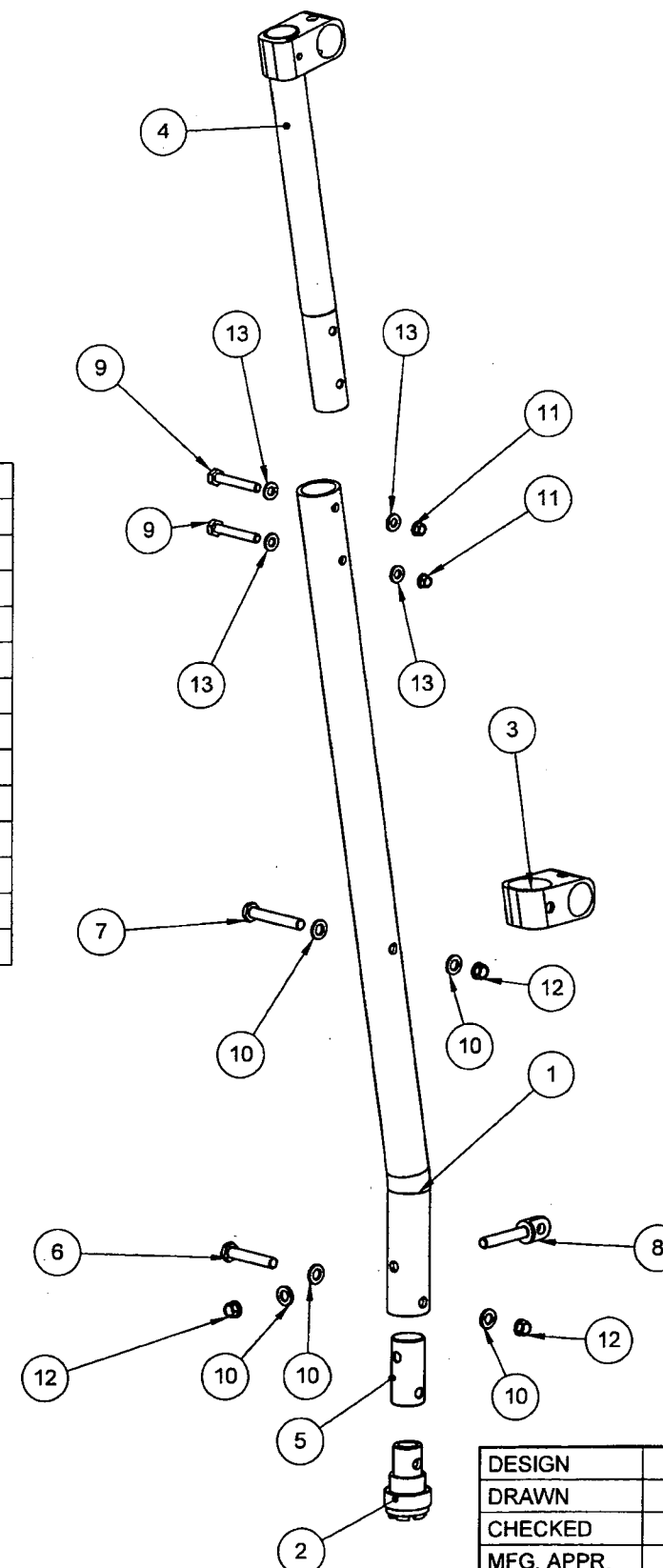
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4




D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



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